

Work Order ID 128615

January-20-15 7:56:31 AM

Handwritten:
D3043-041
B128615
REV. A

128615

Page 1

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 1/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-01-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3043	Rev A

100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G								
	2-Deburr and bevel ends for welding								

Handwritten: 4X DL 15/1/27

110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									

Handwritten: 4X JAN 28 2015 DAS 24 9-89

120	Large Fab	0.00							
120									
Large Fab	Memo	0.00							
Large Fab	1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802								
	AR AL ROD Batch: <u>B130855</u>								
	2-Grind Fwd End Cap weld flush								

Handwritten: 4X CC 15-1-29

Work Order ID 128615

128615

Page 2

January-20-15 7:56:31 AM

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 1/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4		JAN 29 2015	DAS 24 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4		JAN 29 2015	DAS 24 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4x		CC 15-1-29	

Work Order ID 128615

128615

Page 3

January-20-15 7:56:31 AM

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 1/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-1-Weld 1 End Cap as per OSI 004 & Dwg D3043 AR AL ROD Batch: B130855 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

4x CC 15-1-30

4 FEB 02 2015 DAS 24 9-59

4 FEB 02 2015 DAS 24 9-59

Work Order ID 128615

128615

Page 4

January-20-15 7:56:31 AM

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 1/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* HandFinish Hand Finishing	Touch up alodine Memo	0.00 0.00				4X		OK 15/2/12	
210 *210* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 129808. Memo START TIME: 10:45 OVEN TEMPERATURE: 320° FINISH TIME: 11:15	0.00 0.00						4 φ. 15-2-3	OK 3/3
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 111309300 Memo	0.00						4LH f 15/02/01	

Work Order ID 128615

128615

January-20-15 7:56:31 AM

Page 5

Item ID: D3043-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment LH
 Start Date: 1/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00				(4)			DAS 38 9-89
230									
QC	Memo	0.00							
Quality Control									

FEB 06 2015

240 Identify as per dwg & Stock Location: pkc 0.00
240
 Packaging Memo 0.00
 Packaging

4 15-02-6 Sep

250 QC21- Final Inspection - Work Order Release 0.00
250
 QC Memo 0.00
 Quality Control

MLJ 15-02-09

AS2-6

Picklist Print

January-20-15 7:56:30 AM

Page 1

Work Order ID: 128615

128615

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH

Start Date: 1/20/15

Required Date: 3/06/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

111.0000

1

4

D2622-120C

Step Extrusion

DA 15/1/27

Location

Loc Qty

Loc Code

HALL

11

109575

11

WA003

100

125381

100

D2734

Manufactured No

120

Each

66.0000

1

4

D2734

Step End Plate

CC 15-1-29

Location

Loc Qty

Loc Code

WA003

66

124317

45

125805

21

D2734

Manufactured No

160

Each

66.0000

1

4

D2734

Step End Plate

CC 15-1-30

Location

Loc Qty

Loc Code

WA003

66

124317

45

125805

21

Picklist Print

January-20-15 7:56:31 AM

Page 2

Work Order ID: 128615

128615

Parent Item: D3043-041

D3043-041

Parent Item Name: Step Weldment LH

Start Date: 1/20/15

Required Date: 3/06/15

Start Qty: 4.00

Required Qty: 4.00

D3040-1

Manufactured No

120

Each

25.0000

2

8

D3040-1

Mounting Lug

CC 15-1-29

Location

Loc Qty

Loc Code

WA003

25

125837

10

127079

12

80808

3

(8x)

D3040-3

Manufactured No

100

Each

21.0000

2

8

D3040-3

Mounting Lug

CC 15-1-29

Location

Loc Qty

Loc Code

WA003

21

127080

9

83998

12

(8x)



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

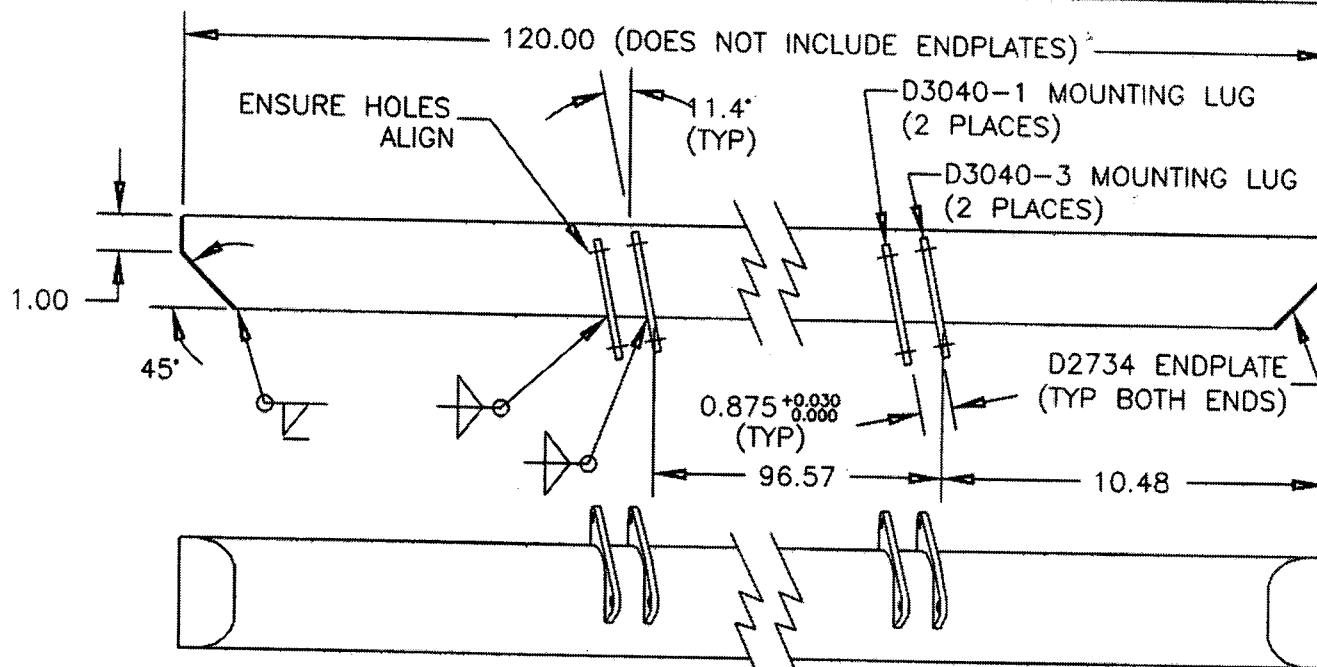
1501-20
128615-413
WORK ORDER
NOTICE
UNCONTROLLED COPY
RETURN TO
ENGINEERING
ATTENTION

Copyright © 2001 by DART AEROSPACE USA, INC.

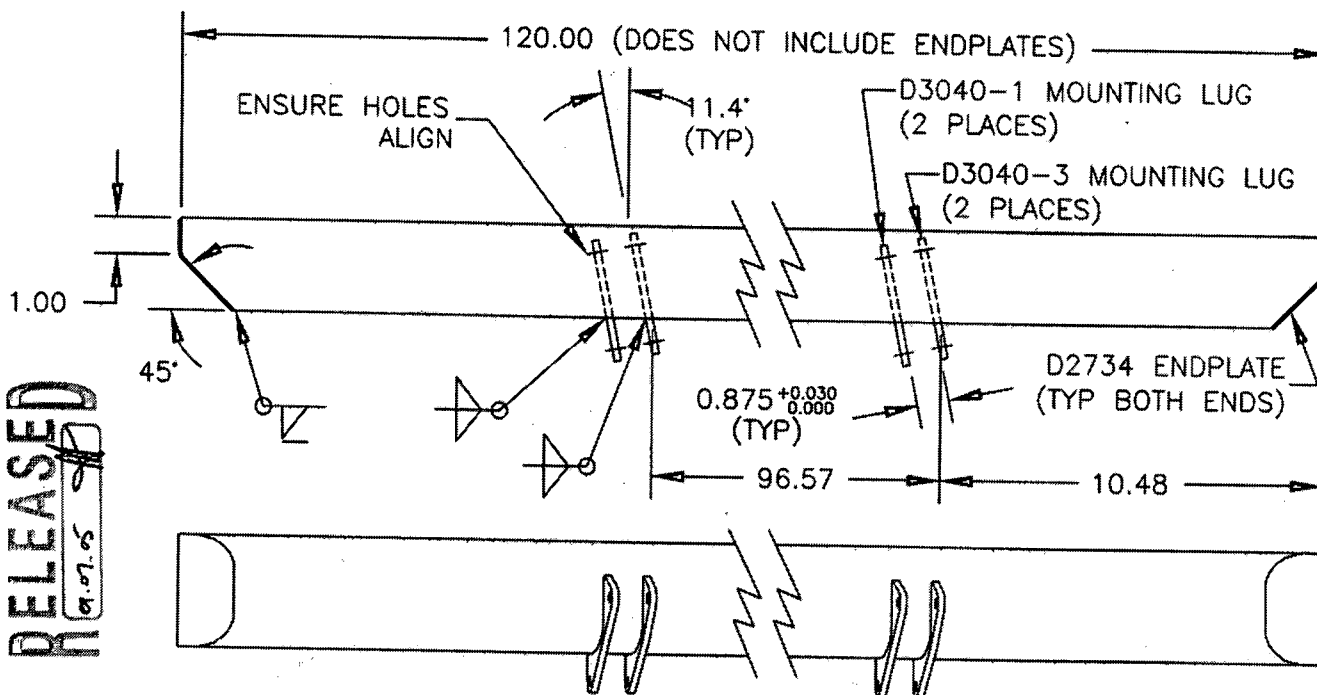
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
R 9.9.5

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.